

Date: Monday, 25/08/2008 9:56:03 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, INBOARD, LS, 206
Job Number	: 41612		
Estimate Number	: 10820		
P.O. Number	:	Part Number	: D26661
This Issue	: 25/08/2008 S.O. No. :	Drawing Number	: D2666 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 38751	Material	:
Written By	:	Due Date	: 20/09/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JLD 08.8.25</u>		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6101001	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 2X6X6.25  
 Issue material from stock:  
 Cut Size 2.0 x 6.25 X 6.0  
 Grain Along Long 6.0 Length

Batch No: B34201

J.F. 08/09/04 (12)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1- Inspect part number and batch number are programmed correctly.  
 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 5- Deburr

J.F. 08/09/04 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

J.F. 08/09/04 (12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/09/04 (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 25/08/2008 9:56:03 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 41612

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25/08/09/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL

08-09-08

(x12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M1108523

START TIME:

1:15pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:45pm

HL

08-09-10

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

HL

08/09/10

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 424

8/9/11

(12)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11

Job Completion



CU 08/09-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 41012
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		124"	120"	126"	120"		
B	0.100	0.140		119"	120"	119"	120"		
C	2.470	2.510		2.494"	2.494"	2.494"	2.494"		
D	0.100	0.180		140"	140"	140"	140"		
E	0.210	0.230		219"	220"	220"	221"		
F	1.313	1.343		1.313"	1.323"	1.323"	1.323"		
G	0.240	0.260		240"	249"	251"	250"		
H	0.615	0.685		664"	664"	664"	664"		
I	1.125	1.145		1.135"	1.135"	1.135"	1.136"		
J	0.990	1.010		997"	1,001"	1,001"	1,001"		
K	0.235	0.240		237"	237"	237"	237"		
L	0.510	0.515		510"	510"	510"	510"		
M	0.100	0.120		110"	110"	110"	110"		
N	1.565	1.585		1,575"	1,575"	1,575"	1,576"		
O	5.990	6.010		6,001"	6,001"	6,001"	6,001"		
P	1.245	1.255		1,249"	1,249"	1,249"	1,249"		
Q	2.495	2.505		2,501"	2,501"	2,501"	2,501"		
R	0.490	0.510		505"	504"	506"	504"		
S	0.313	0.318		314"	314"	314"	314"		
T	2.495	2.505		2,501"	2,501"	2,501"	2,501"		
U	1.357	1.367		1,363"	1,363"	1,363"	1,363"		
V	0.315	0.322		320"	320"	320"	320"		
W	0.540	0.560		552"	553"	552"	552"		
X	1.674	1.684		1,680"	1,680"	1,680"	1,680"		
Y	0.257	0.262		258"	258"	258"	258"		
Z	0.178	0.198		188"	188"	188"	188"		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.
Date: 08/09/03

Audited by: [Signature]
Date: 08/09/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	[Signature]

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 41612
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.100	0.140		.120"	.120"	.119"	.116		
B	0.100	0.140		.121"	.120"	.120"	.121		
C	2.470	2.510		2.494"	2.494"	2.494"	2.492		
D	0.100	0.180		.140"	.140"	.140"	.146		
E	0.210	0.230		.221"	.220"	.220"	.220		
F	1.313	1.343		1.323"	1.323"	1.323"	1.323		
G	0.240	0.260		.249"	.252"	.250"	.250		
H	0.615	0.685		.664"	.664"	.664"	.657		
I	1.125	1.145		1.136"	1.136"	1.136"	1.135		
J	0.990	1.010		1.001"	1.001"	1.000"	1.000		
K	0.235	0.240		.237"	.237"	.237"	.237		
L	0.510	0.515		.510"	.510"	.510"	.510		
M	0.100	0.120		.110"	.110"	.110"	.110		
N	1.565	1.585		1.576"	1.576"	1.576"	1.570		
O	5.990	6.010		6.001"	6.001"	6.001"	5.999		
P	1.245	1.255		1.249"	1.249"	1.249"	1.250		
Q	2.495	2.505		2.501"	2.501"	2.501"	2.500		
R	0.490	0.510		.502"	.497"	.502"	.503		
S	0.313	0.318		ø .314"	ø .314"	ø .314"	.314		
T	2.495	2.505		2.501"	2.501"	2.501"	2.500		
U	1.357	1.367		1.363"	1.363"	1.363"	1.361		
V	0.315	0.322		ø .320"	ø .320"	ø .320"	.320		
W	0.540	0.560		.551"	.553"	.552"	.550		
X	1.674	1.684		1.680"	1.680"	1.680"	1.680		
Y	0.257	0.262		ø .258"	ø .258"	ø .258"	.259		
Z	0.178	0.198		R.188"	R.188"	R.188"	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F. 10ml	Audited by: RF
Date: 08/08/04	Date: 08/09/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41012
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2666-1
<b>Inspection Dwg:</b> D2666 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.100	0.140		.116	.119	.116	.117		
B	0.100	0.140		.121	.121	.122	.122		
C	2.470	2.510		2.491	2.490	2.490	2.490		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.219	.219	.221	.221		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.240	0.260		.249	.249	.247	.248		
H	0.615	0.685		.657	.650	.655	.650		
I	1.125	1.145		1.135	1.135	1.135	1.135		
J	0.990	1.010		1.001	1.000	1.000	1.000		
K	0.235	0.240		.238	.238	.237	.237		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.110	.110	.110	.110		
N	1.565	1.585		1.570	1.570	1.571	1.570		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.502	.502	.503	.500		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.499		
U	1.357	1.367		1.362	1.361	1.361	1.361		
V	0.315	0.322		.320	.320	.320	.320		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.677	1.679	1.679	1.680		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	aml
Date:	08/09/04

Audited by:	SS
Date:	08/09/06

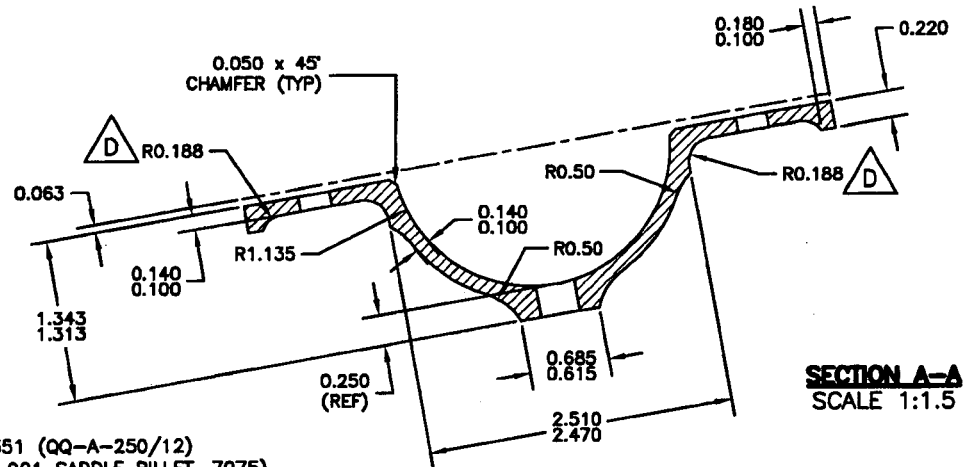
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

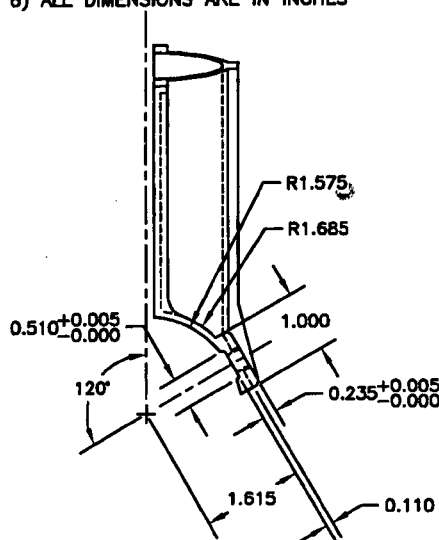
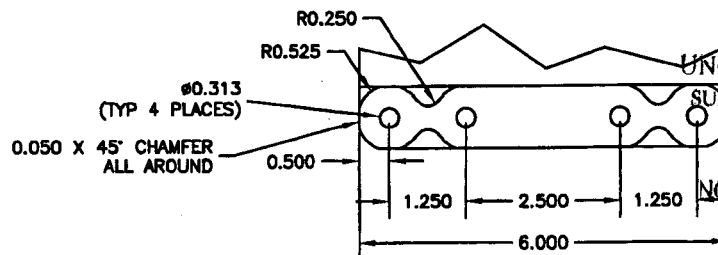
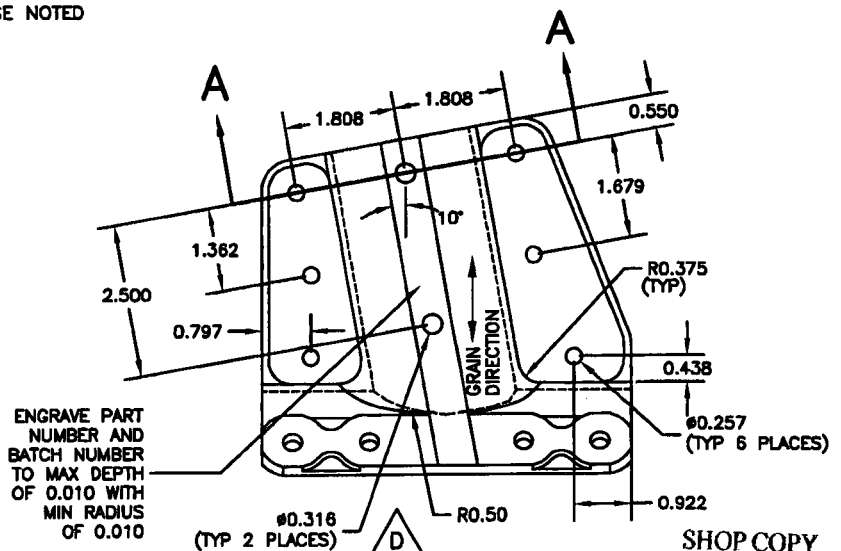
RELEASED

07.02.12 #



## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



